

532

DART AEROSPACE LTD		Work Order:	20915
Description: Lug		Part Number:	D2807-3
Dwg: D2807 Rev. <i>C</i> <i>05.08.01</i>		Qty:	100
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AR	05/08/02	100
2	MC	Turn as per Folio FA529 and Dwg D2807 Material: 303 Round Bar Ø0.750" (M303R0.750)	Dwg Rev: <i>C</i> Folio Rev: <i>A</i> Batch: <i>M17210</i> <i>M17821</i>	<i>05.08.03</i>	<i>100</i>
3	QC2	Inspect parts as they come off the machine	<i>05.08.05</i>	<i>100</i>	
4	MC	Deburr	<i>SG</i>	05/08/10	100
5	MV	Machine as per Folio FA528 and Dwg D2807	Dwg Rev: <i>C</i> Folio Rev: <i>C</i>	<i>SD</i> <i>05.08.13</i>	<i>100</i>
6	QC2	Inspect parts as they come off the machine	<i>SD</i>	<i>05.08.13</i>	<i>100</i>
7	MV	Deburr	<i>SD</i>	<i>05.08.13</i>	<i>100</i>
8	QC8	Second check	<i>R</i>	<i>05.08.15</i>	<i>100</i>
9	ST	Identify and Stock	<i>SB</i>	<i>05/08/15</i>	<i>100</i>
10	AC	Cost / part: <i>4.02</i>	<i>AP</i>	<i>05/08/17</i>	<i>100</i>
11	DC	Close W/O <i>4.02</i> Inspect Level 21	<i>Q</i>	<i>05/08/16</i>	<i>100</i>

Rev	Date	Change	Revised By	Approved
A	05.06.02	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
05/08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DS* Date: 05/08/17

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

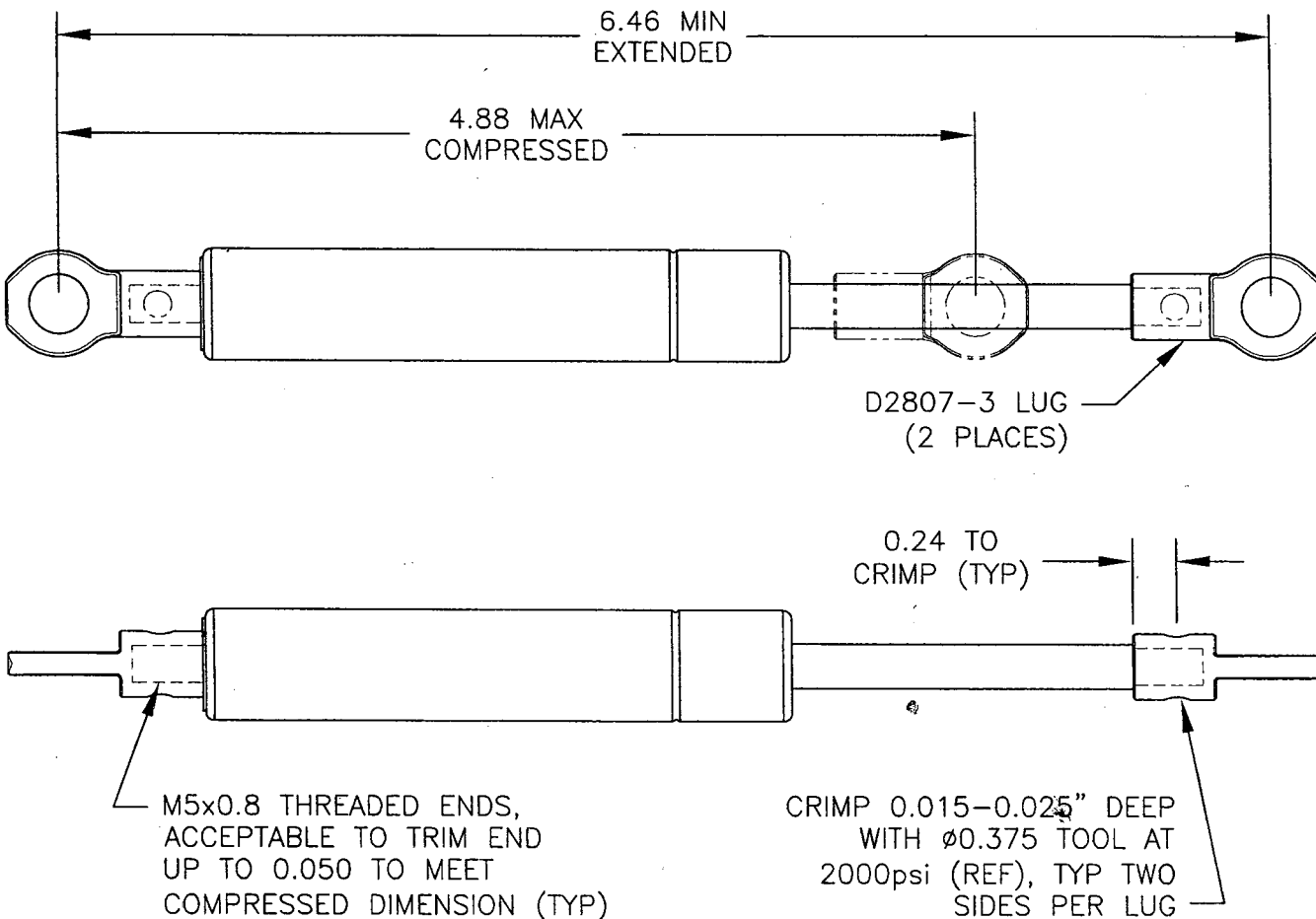
RELEASED
#05.06.16

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP	DRAWING NO.	REV. C
CHECKED	APPROVED	D2807	SHEET 1 OF 2
DATE		TITLE	SCALE
05.05.25		GAS SPRING	1:1
A	00.11.03	NEW ISSUE	
B	05.03.16	ADD FINISH	
C	05.05.25	CHANGE SPRING TO CSS, ADD -3 LUG	

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WORK ORDER
NO. 23915



D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

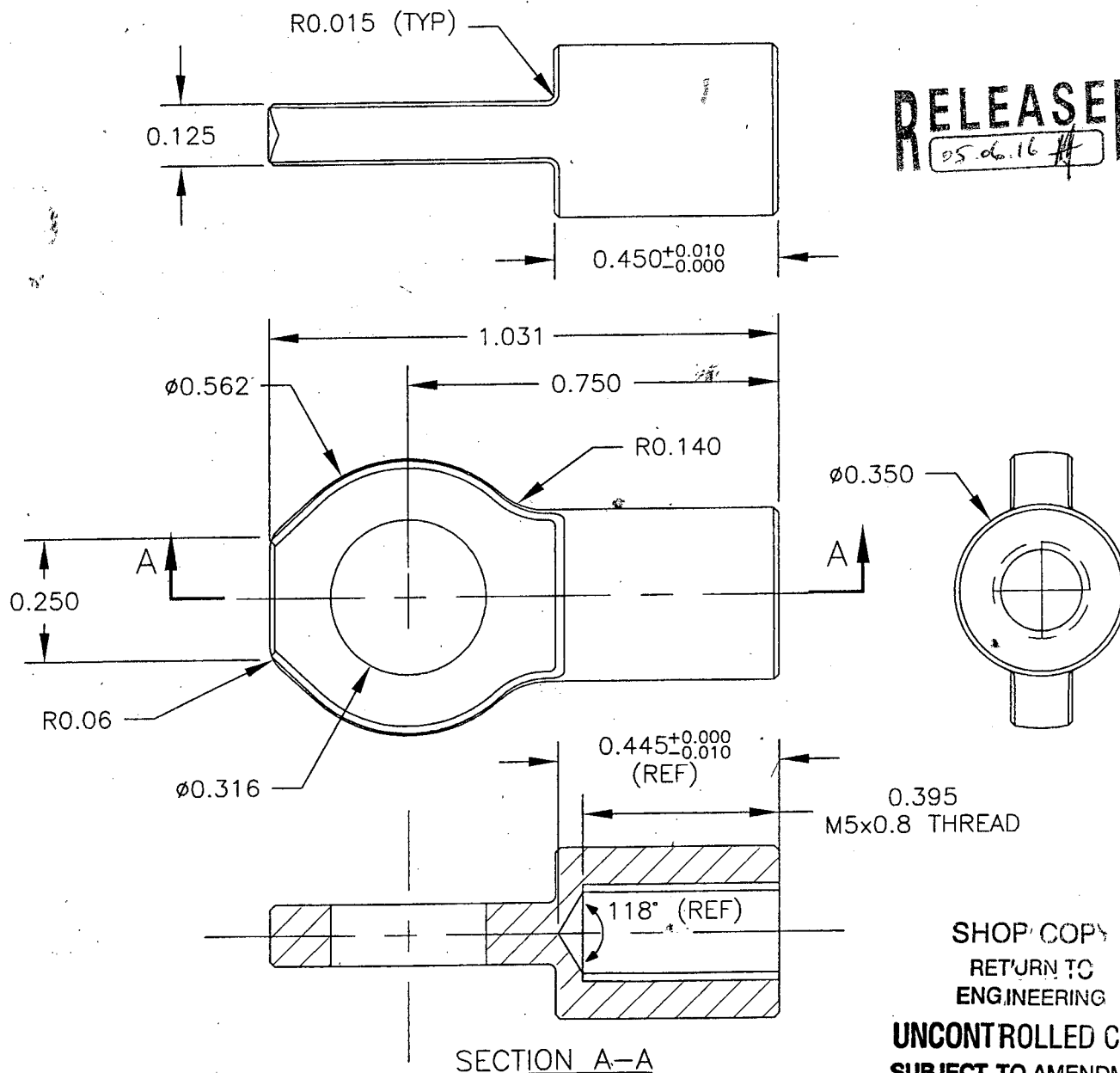
POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25		TITLE GAS SPRING	SCALE 3:1

RELEASED
05.06.16



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 02, 2005
01:38 pm

Work Order No	: 0023915	Department Code:	
Project Name	: D2807-3	Burden Flags	: NNNNNNNN
Project For	: WK532	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2807-3	Invoice Number	:
Description	: Lug	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 100	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-02-05		
Est Finish Date	: 08-10-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

